

Work Order ID 63324

Wednesday, October 27, 2010 3:02:02 PM



Page 1

Item ID:	D3065-041	Accept		Setup	Start	
Revision ID:						
Item Name:	Step Leg Assembly Hi				Stop	
Start Date:	10/27/2010	Start Qty:	40.00			
Required Date:	11/11/2010	Req'd Qty:	40.00			
Reference:						

Approvals:	Process Plan:		Date:	10/10/27	Tooling:		Date:		Run	Start	
	QC:		Date:		SPC (Y/N):		Date:			Stop	

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr								
D3065	Rev B								
100		0.00							
	Small Fab								
Small Fab	Memo	0.00							
Small Fab	Assemble as per Dwg D3065 and Identify as D3065-041								
110		0.00							
	QC5- Inspect part completeness to step on W/O								
QC	Memo	0.00							
Quality Control									
120		0.00							
	Identify as per dwg & Stock Location: <u>WA</u>								
Packaging	Memo	0.00							
Packaging									

Handwritten: 10/11/15 (40)

Handwritten: SB 10/11/15 (40)

Handwritten: 10.11.15 40

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____
 Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Work Order ID 63324

Wednesday, October 27, 2010 3:02:02 PM

Page 2

Item ID: D3065-041

Accept

Setup Start

Revision ID:

Stop

Item Name: Step Leg Assembly Hi

Start Date: 10/27/2010 Start Qty: 40.00

Cust Item ID:

Required Date: 11/11/2010 Req'd Qty: 40.00

Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start

QC:

Date:

SPC (Y/N):

Date:

Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

130

QC21- Final Inspection - Work Order Release

0.00



QC

Memo

0.00

Quality Control

10/11/15 *[Signature]*
PS 10-11-15
(70)

W/O:		WORK ORDER CHANGES					
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NOTE: Date & initial all entries

Picklist Print

Wednesday, October 27, 2010 3:02:06 PM

Page 1

Work Order ID: 63324

Parent Item: D3065-041

Parent Item Name: Step Leg Assembly Hi

Start Date: 10/27/2010

Required Date: 11/11/2010

Start Qty: 40.00

Required Qty: 40.00

Comments: IPP Rev: C02.11.01 Incorporated D3066-1 IPP KJ/RF

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
D3065-1 Step Spacer		Manufactured	No			100	Each	18.0000	1	40			
				<u>Location</u>				<u>Loc Qty</u>		<u>Loc Code</u>			
				GA				18					
					59860			1					
					61416			17					
D3065-3 Step Spacer		Manufactured	No			100	Each	12.0000	1	40			
				<u>Location</u>				<u>Loc Qty</u>		<u>Loc Code</u>			
				GA				2					
					61415			2					
				WA				10					
					48113			10					
D3065-5 Step Leg		Manufactured	No			100	Each	48.0000	2	80			
				<u>Location</u>				<u>Loc Qty</u>		<u>Loc Code</u>			
				GA				48					
					61841			8					
					62670			40					
D3065-7 Step Spacer		Manufactured	No			100	Each	30.0000	1	40			
				<u>Location</u>				<u>Loc Qty</u>		<u>Loc Code</u>			
				GA				30					
					62404			30					

EP 10/11/15
B63444 (22x)

EP 10/11/15
B62679 (16x)

EP 10/11/15
B63445 (3x)

EP 10/11/15
B63446 (32x)

EP 10/11/15
B63447 (10x)

W/O:		WORK ORDER CHANGES					
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NOTE: Date & initial all entries

Picklist Print

Wednesday, October 27, 2010 3:02:07 PM

Page 2

Work Order ID: 63324



Parent Item: D3065-041



Parent Item Name: Step Leg Assembly Hi

Start Date: 10/27/2010

Required Date: 11/11/2010

Start Qty: 40.00

Required Qty: 40.00

MS20470AD4-4

Purchased

No

100

Each

2,288.000

30

1200



Rivet, Universal Head

EP 10/11/15

Location

Loc Qty

Loc Code

ST319

2288

112314

30

113368

92

115470 -

2166

1200

Wednesday, October 27, 2010 3:02:07 PM

Shop Packet Print

Page 2

Dart Aerospace Ltd

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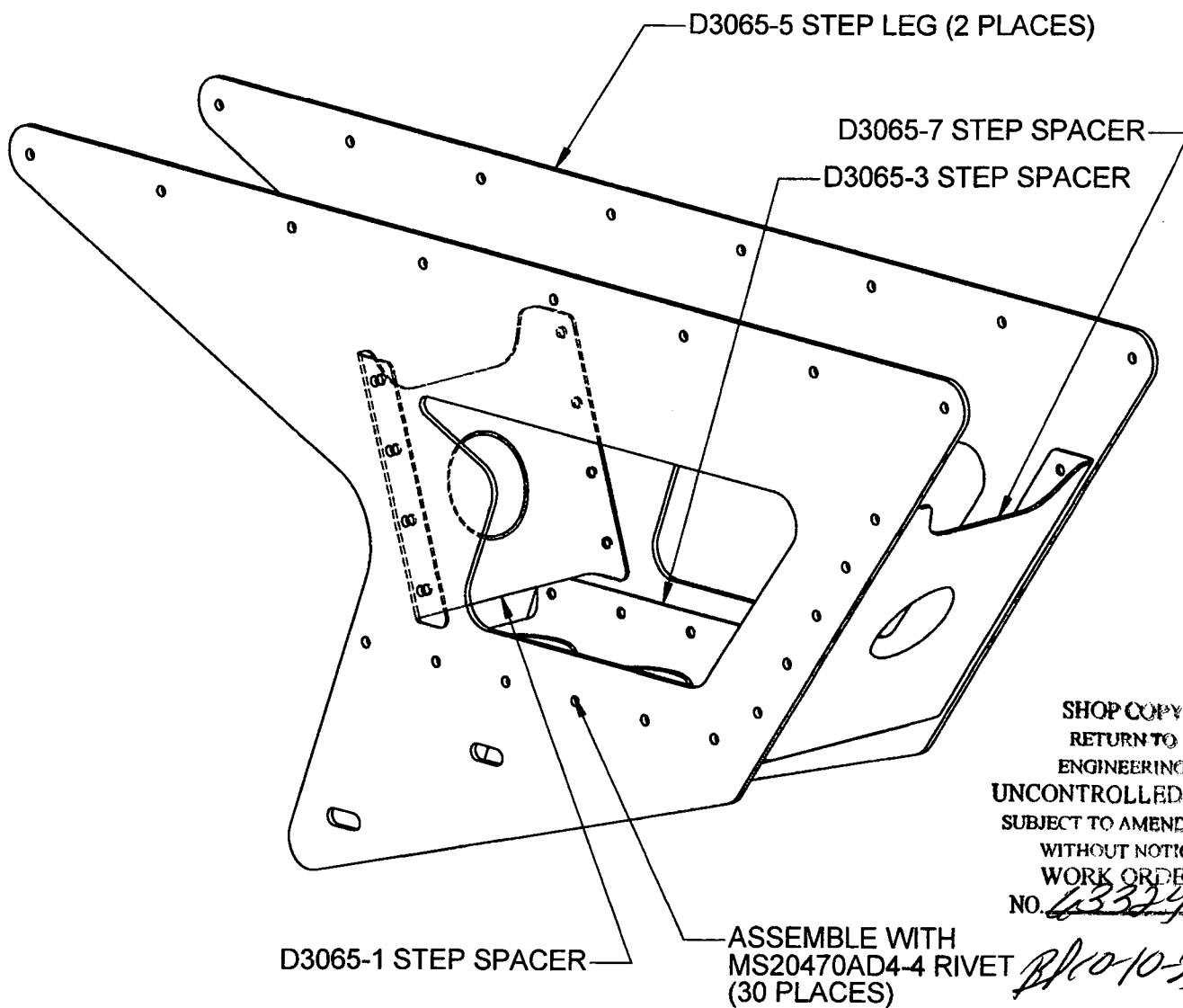
NOTE: Date & initial all entries



DESIGN <i>CP</i>	DRAWN BY <i>CB</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>PH</i>	APPROVED <i>[Signature]</i>	DRAWING NO. D3065	REV. B SHEET 1 OF 5
DATE 06.05.23		TITLE STEP LEG ASSEMBLY	SCALE 1:2
A	02.09.11	NEW ISSUE	
B	06.05.23	ADD 6061-T6 MATERIAL, ADD SLOTS TO D3065-5	

RELEASED

06.06.20 *[Signature]*



D3065-041 STEP LEG ASSEMBLY

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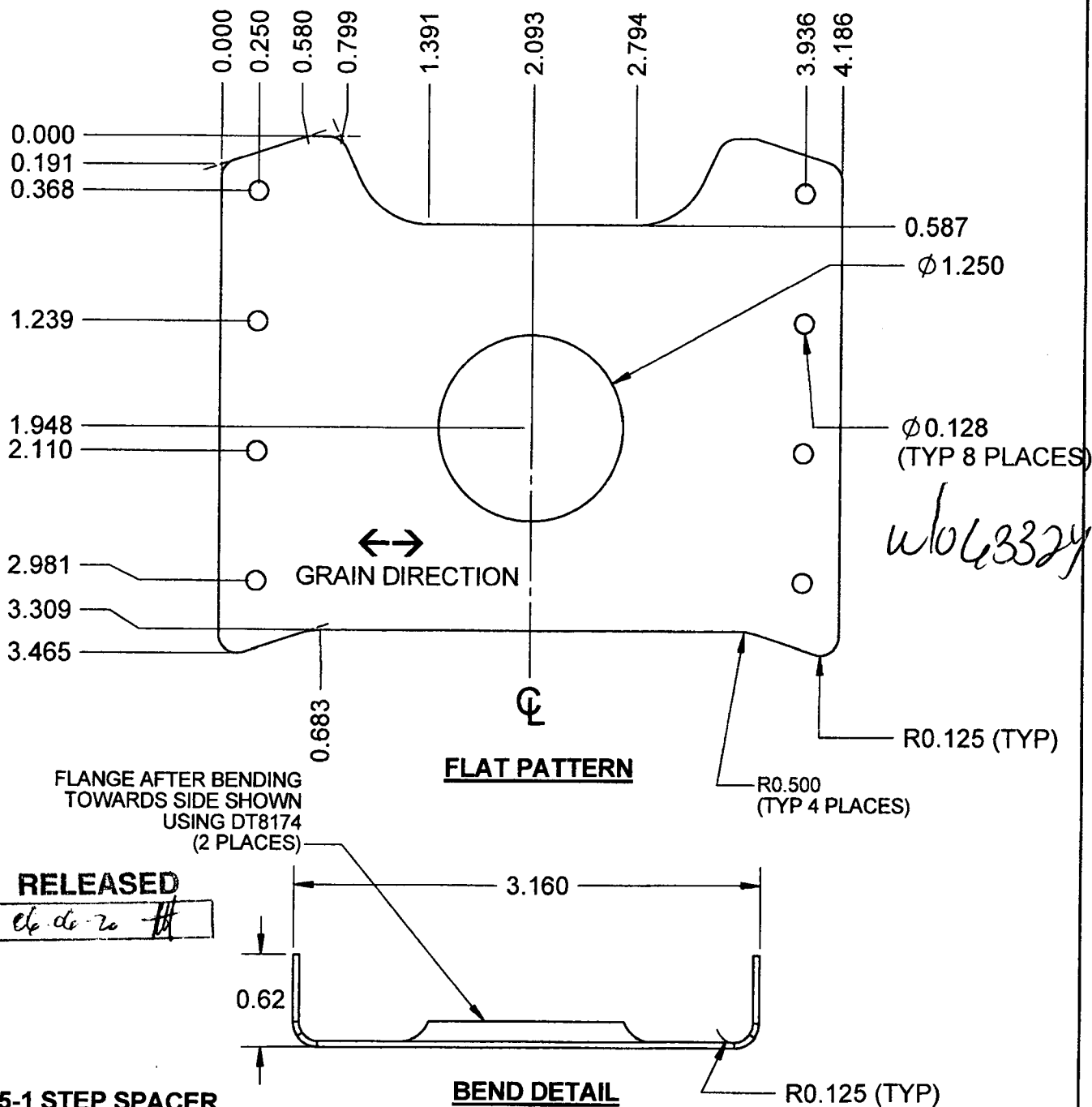
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NOTE: Date & initial all entries



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CHECKED <i>PH</i>	APPROVED <i>[Signature]</i>	DRAWING NO. D3065	REV. B SHEET 2 OF 5
DATE 06.05.23		TITLE STEP LEG ASSEMBLY	SCALE 1:1



- 1) MATERIAL: 2024-T3 (QQ-A-250/4) 0.040 THICK (REF DART SPEC. M2024T3S.040)
- 2) FINISH: ACID ETCH & ALODINE PER DART QSI 005 4.1
- 3) BREAK ALL SHARP EDGES 0.005 TO 0.010
- 4) PART IS SYMMETRIC ABOUT CENTERLINE
- 5) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 6) ALL DIMENSIONS ARE IN INCHES

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Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

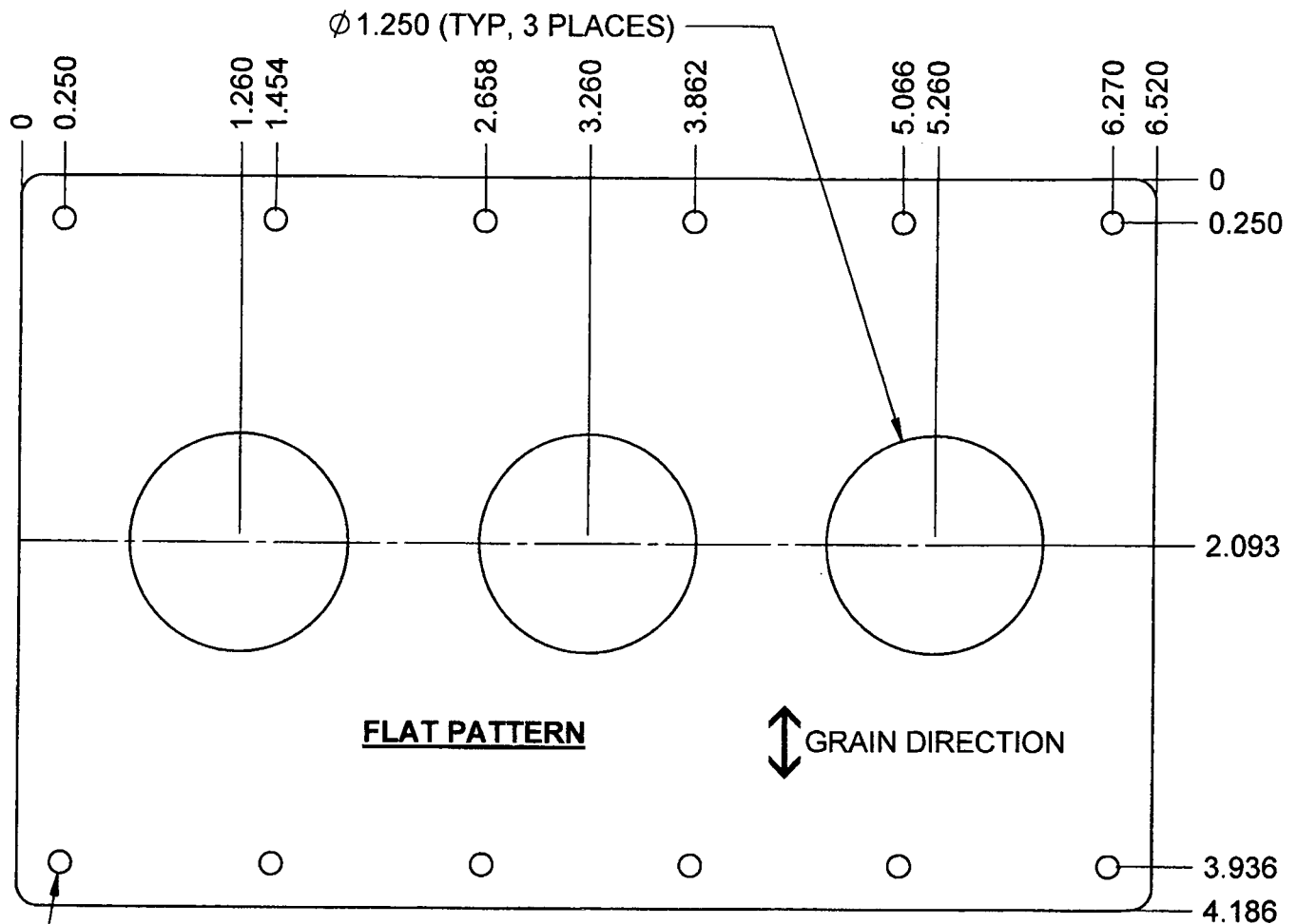
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DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
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NOTE: Date & initial all entries

u/b 43324



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CHECKED <i>PH</i>	APPROVED <i>[Signature]</i>	DRAWING NO. D3065	REV. B SHEET 3 OF 5
DATE 06.05.23	TITLE STEP LEG ASSEMBLY		SCALE 1:1

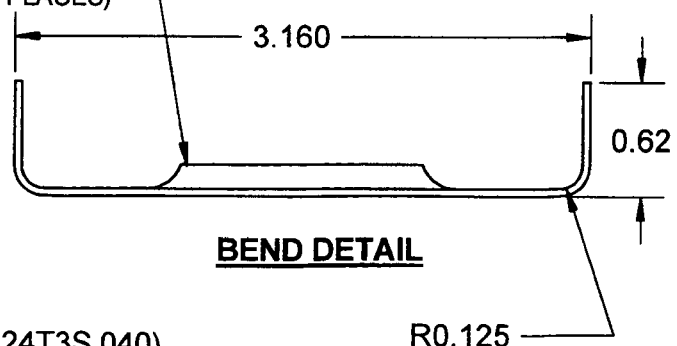


FLANGE AFTER TOWARDS SIDE
SHOWN USING DT8174 (3 PLACES)

Ø 0.129 (TYP, 12 PLACES)

RELEASED

06.06.20 *[Signature]*



BEND DETAIL

D3065-3 STEP SPACER

- 1) MATERIAL: 2024-T3 (QQ-A-250/4)
0.040 THICK (REF DART SPEC. M2024T3S.040)
- 2) FINISH: ACID ETCH & ALODINE PER DART QSI 005 4.1
- 3) PART IS SYMMETRIC ABOUT CENTERLINE
- 4) BREAK ALL SHARP EDGES 0.005 TO 0.010
- 5) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 6) ALL DIMENSIONS ARE IN INCHES

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Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

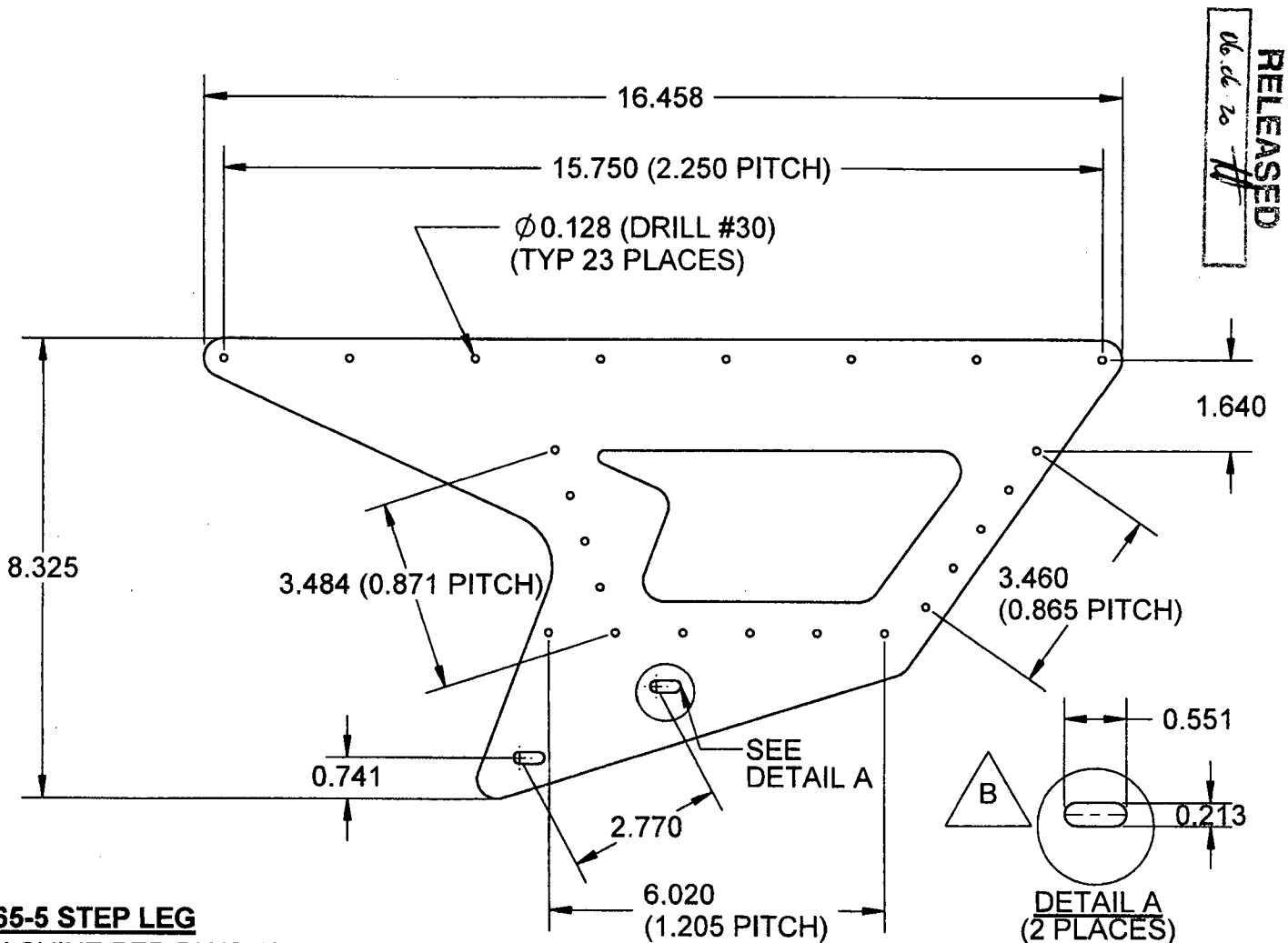
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NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

DART

DESIGN	DRAWN BY	DART AEROSPACE LTD
CHECKED	APPROVED	HAWKESBURY, ONTARIO, CANADA
06.05.23	06.05.23	D3065
DATE	TITLE	STEP LEG ASSEMBLY
	SCALE	1:3
	REV. B	SHEET 4 OF 5

**D3065-5 STEP LEG**

- 1) MACHINE PER DWG FILE "D3065-5.SLDPRJT"
- 2) MATERIAL: 6061-T6 (PER QQ-A-250/11 OR AMS 4025 OR AMS 4027) 0.080" THICK
(REF DART SPEC M6061T6S.080)
OR
5052-H32 (PER QQ-A-250/8 OR AMS 4016) 0.080 THICK (REF DART SPEC. M5052H32S.080)
- 3) FINISH: ACID ETCH & ALODINE PER DART QSI 005 4.1
- 4) BREAK ALL SHARP EDGES 0.005 TO 0.010
- 5) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
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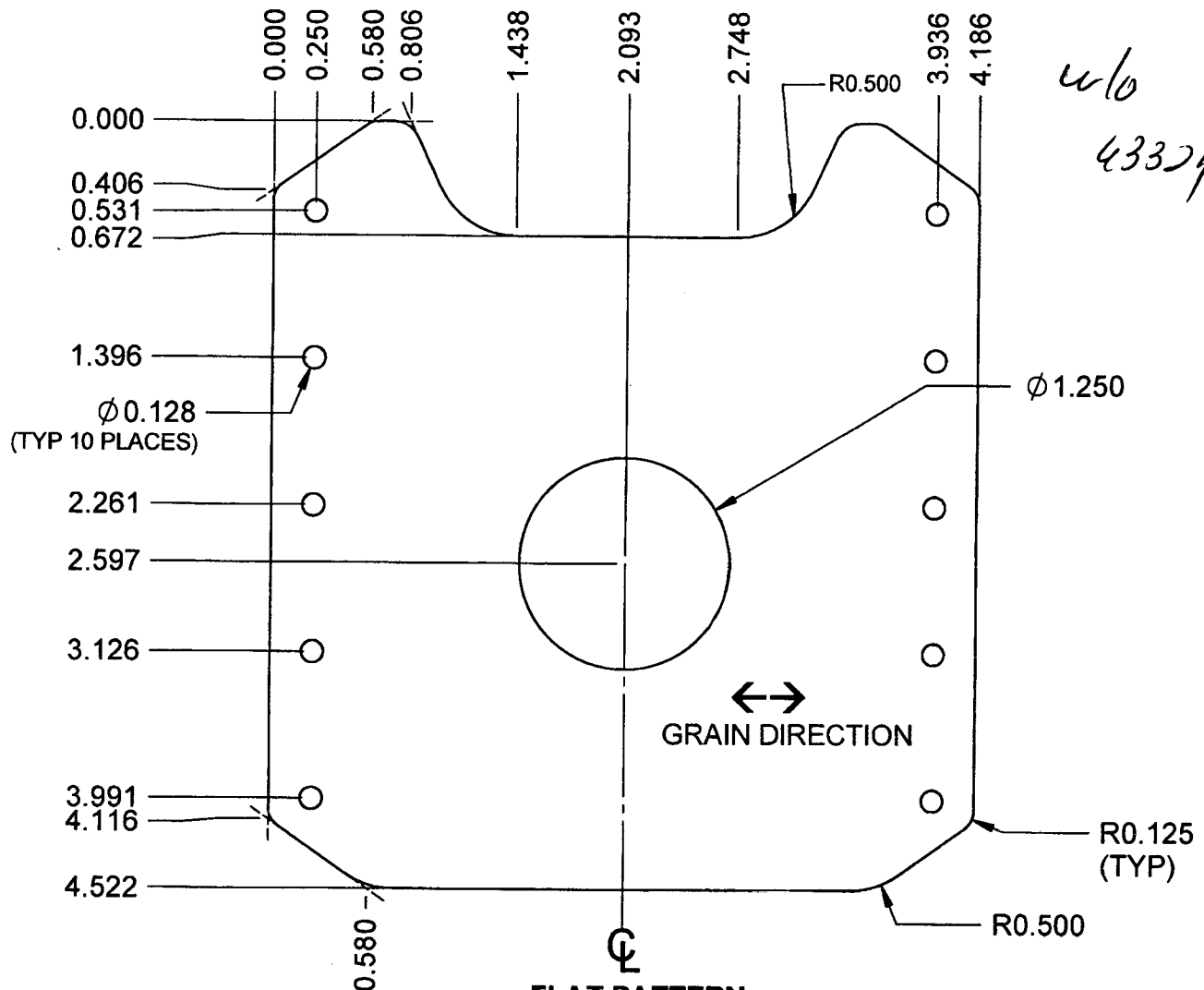
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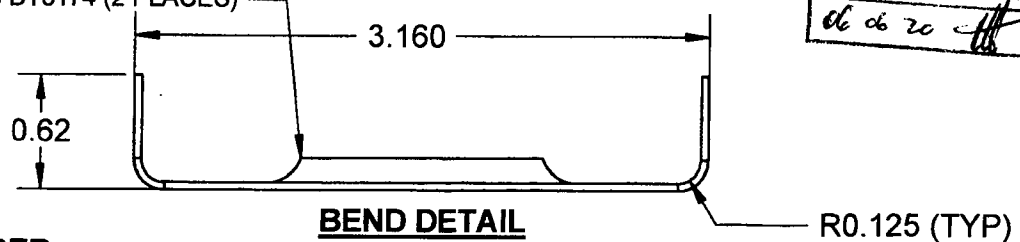
DART

DESIGN <i>CP</i>	DRAWN BY <i>CB</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>PH</i>	APPROVED <i>[Signature]</i>	DRAWING NO. D3065	REV. B SHEET 5 OF 5
DATE 06.05.23	TITLE STEP LEG ASSEMBLY		SCALE 1:1



FLANGE AFTER BENDING TOWARDS
SIDE SHOWN USING DT8174 (2 PLACES)

FLAT PATTERN

RELEASED

BEND DETAIL

D3065-7 STEP SPACER

- 1) MATERIAL: 2024-T3 (PER QQ-A-250/4) 0.040 THICK (REF DART SPEC. M2024T3S.040)
- 2) FINISH: ACID ETCH & ALODINE PER DART QSI 005 4.1
- 3) PART IS SYMMETRIC ABOUT CENTERLINE
- 4) BREAK ALL SHARP EDGES 0.005 TO 0.010
- 5) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
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